

Work Order ID 85249

85249

June-05-12 9:11:05 AM

Page 1

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3391	I
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100	0.00
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100

DOCUMENT CONTROL

DC

Document Control

Memo 0.00

If D412-742-043 is a W/O on its own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005

N/A 

Work Order ID 85249

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Page 3

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 05/06/2012 Start Qty: 1.00 *1*

Required Date: 19/06/2012 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 8524927							

130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____	0.00 PPP86520							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 12/15/12							

ME
12-07-04

Picklist Print

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Page 1

Work Order ID: 85249

85249
D412-742-043

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM

IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC

IPP Rev:C 07-05-28 As per Rev F JLM

IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F

11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3391-021		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3391-021 *N* *Med in D3391-021* *3* *110612*

Fwd Tube Assembly

D3391-023		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3391-023 *A* *Med in D3391-023* *110612*

Mid Tube Assembly

Location Loc Qty Loc Code

FP 1 _____

GA -1 _____

D3391-025		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3391-025 *Aft Tube Assembly* *110612*

AN3C4A		Purchased	No			110	Each	1,362.000	24	24			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--

AN3C4A *110612*

BOLT

Location Loc Qty Loc Code

ST350 1362 _____

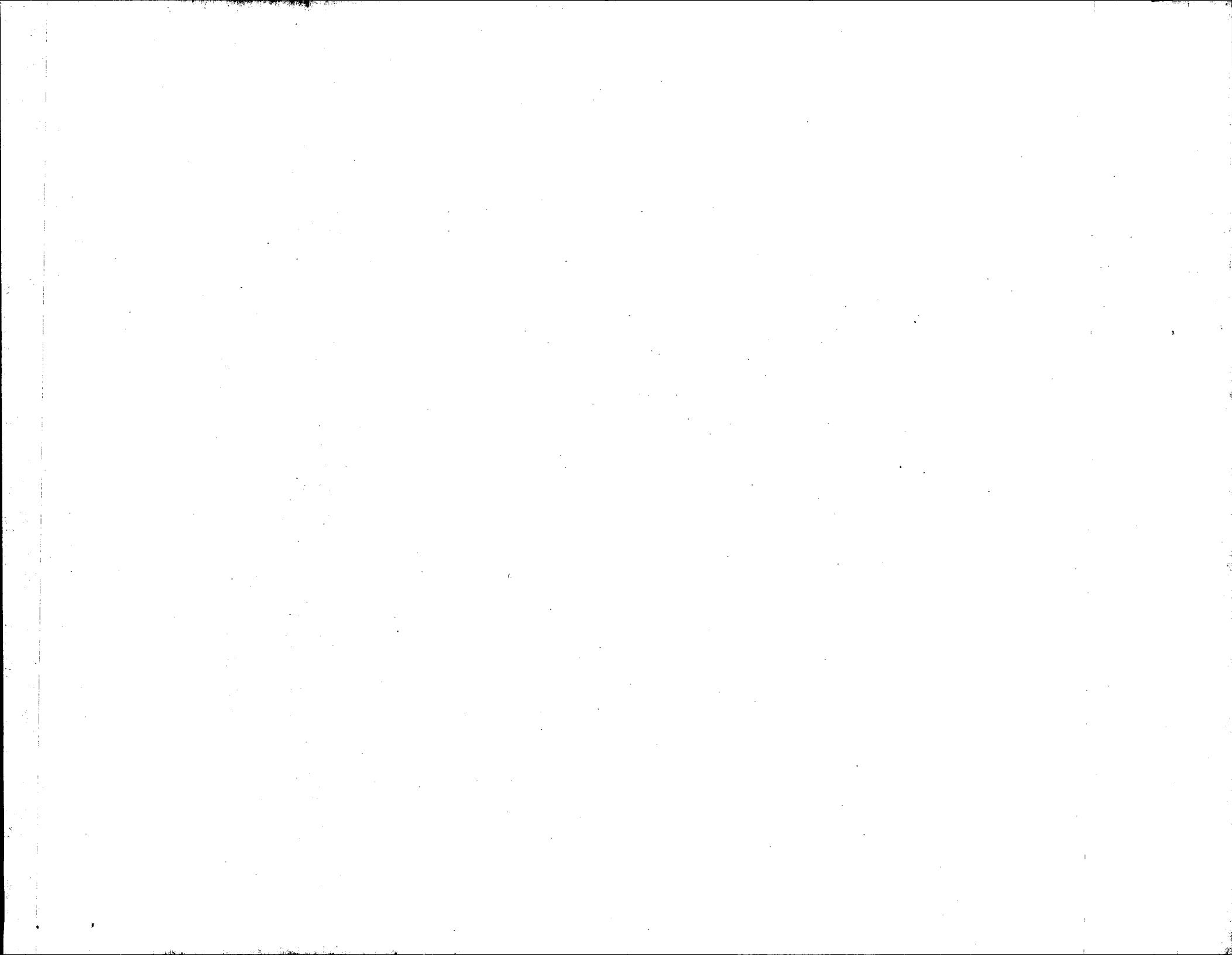
120187 57 _____

120521 28 _____

120769 38 _____

121205 1000 *Y24* _____

121556 239 _____



NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Offset/Setup										
Other										
Process										
Supplier										
Training										
Unauthorized										
FAULT CATEGORY										
Landing Gear	Hardware			General						
	<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Set-up					
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Supplier					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Off-Set	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Other					
	<input type="checkbox"/> Positioned Wrong	Drill Holes			<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Outside Dimensions				
	<input type="checkbox"/> Ripples on Inner Bend	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance						
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost						
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved						
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Too Many	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material						

Picklist Print

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Work Order ID: 85249

85249

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

451.0000

10

10

**

HL 1206126***AN3C6A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
111982	1	
ST351	450	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	158	
<u>121682</u>	200	

AN3C7A

Purchased

No

110

Each

140.0000

4

4

**

HL 1206126***AN3C7A***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	140	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
<u>121185</u>	50	
121541	38	

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Shop Packet Print

Page 2

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Engineering
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Quality
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Supplier	<input type="checkbox"/>	
	Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Other	<input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear	Hardware	General		
<input type="checkbox"/> Bending Passes Below Min	Breaking	<input type="checkbox"/> Burrs	Maintenance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Centre Not Concentric to O/S	Missing	<input type="checkbox"/> Contamination	Mislabeled	<input type="checkbox"/> Supplier
<input type="checkbox"/> Cracks	Size/Length	<input type="checkbox"/> Cut Too Short	Off-Set	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crushed/Crimp at Bending	Spinning	<input type="checkbox"/> Documentation/Data	Orientation Misread	<input type="checkbox"/> Weld
<input type="checkbox"/> Inspection Strip in Tube	Threading	<input type="checkbox"/> Finish	Out of Calibration	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other	Wrong	<input type="checkbox"/> Inspection Incomplete	Out of Sequence	<input type="checkbox"/> Other
<input type="checkbox"/> Positioned Wrong	Drill Holes	<input type="checkbox"/> Inspection Unqualified	Outside Dimensions	
<input type="checkbox"/> Ripples on Inner Bend	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Instructions Incomplete/Unclear	Over/Under tolerance	
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Jigs/Fixtures/Tooling	Part Lost	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Incorrect	Part Moved	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Too Many	<input type="checkbox"/> Kit Missing	Raw Material	

Picklist Print

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Work Order ID: 85249

85249

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

38

38

**

M22063 (x38) 46 12/06/20

AN960C10L X

washer

D4095-041

Manufactured

No

110

Each

0.0000

1

1

**

B81623 (x1) 46 12/06/20

D4095-041

Wearplate Assembly

D4095-043

Manufactured

No

110

Each

1.0000

1

1

**

46 12/06/20

D4095-043

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001

1

81624

1

D4095-045

Manufactured

No

110

Each

15.0000

1

1

**

46 12/06/20

D4095-045

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP

1

81625

1

FP001

14

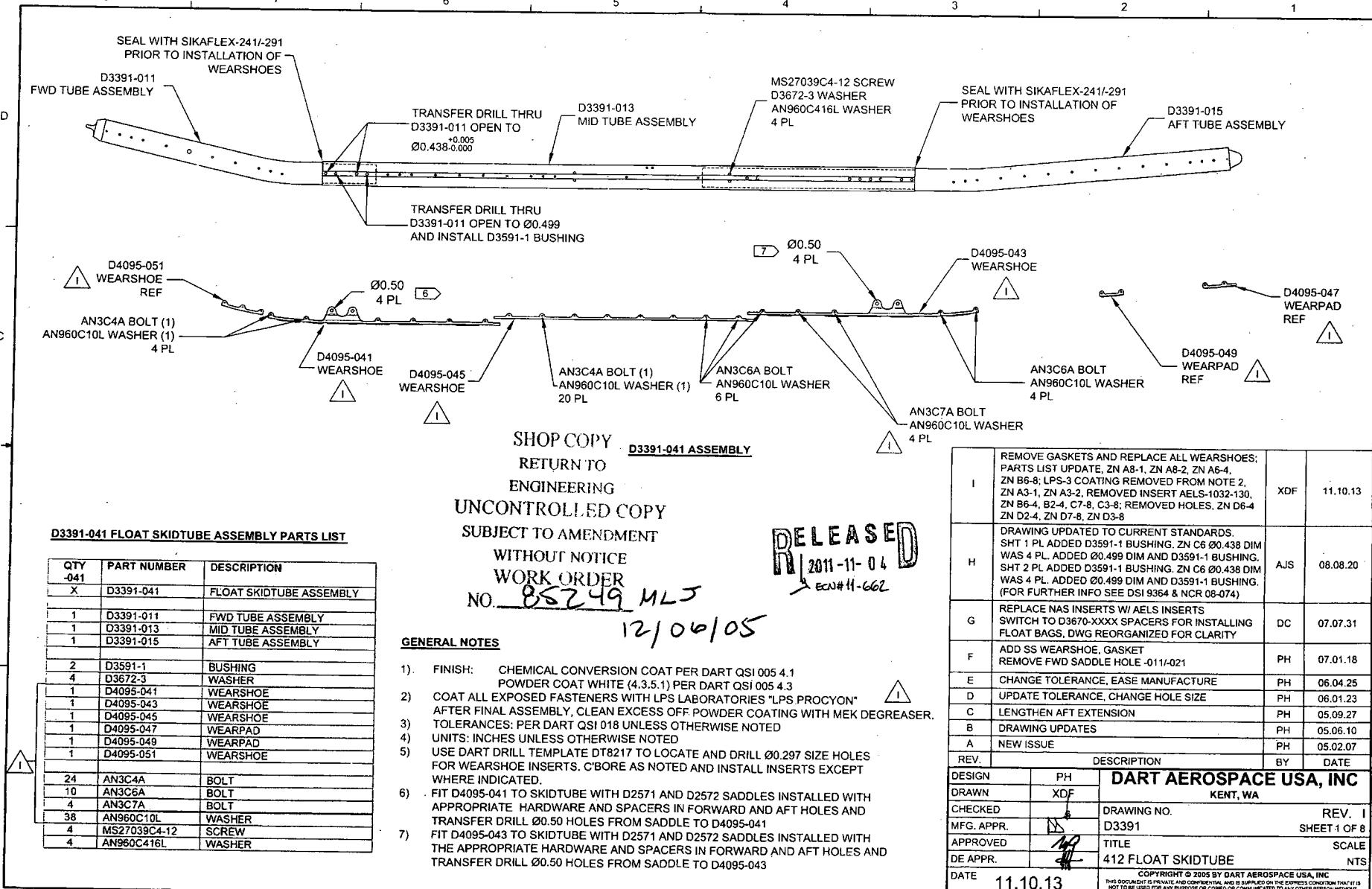
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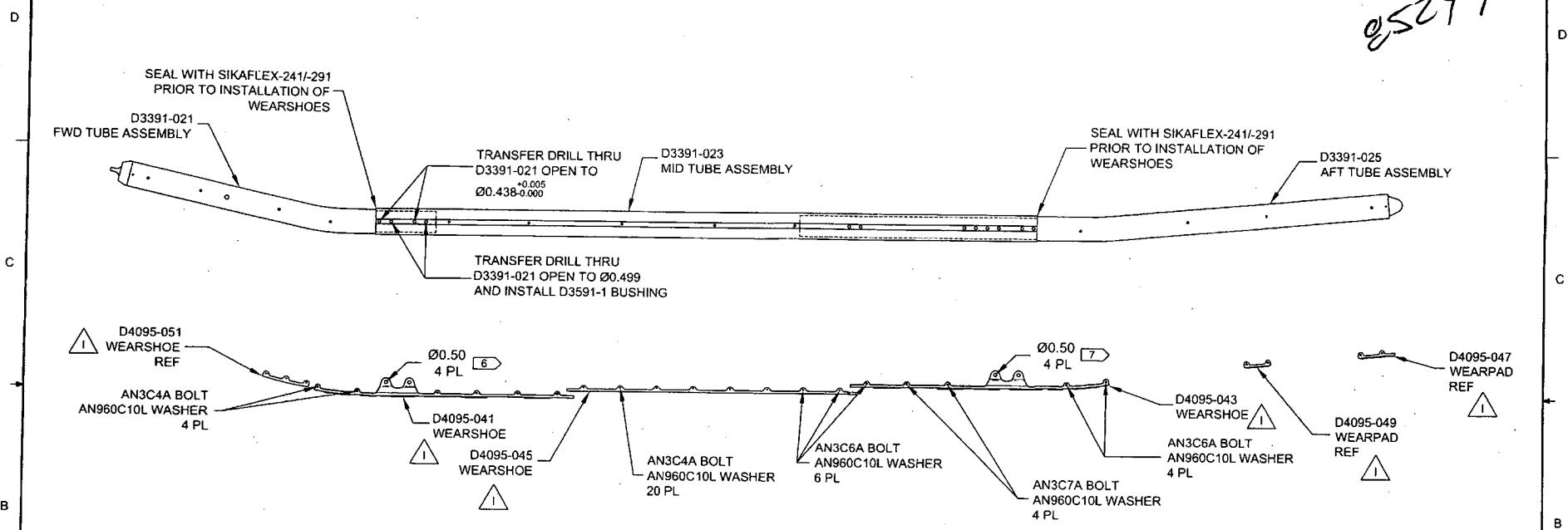
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13

46 12/06/20



8 7 6 5 4 3 2 1

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-043	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

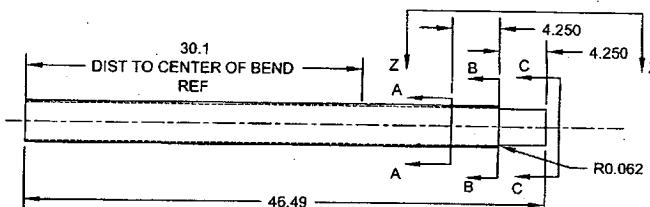
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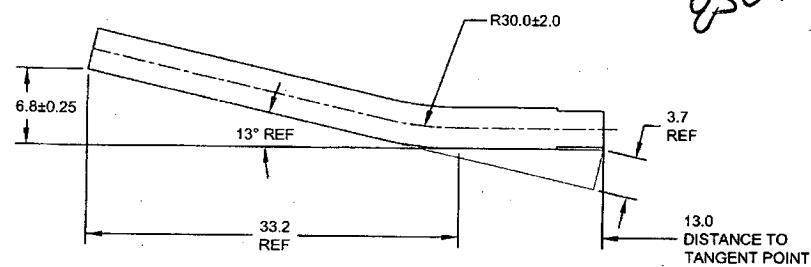
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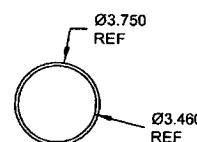


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

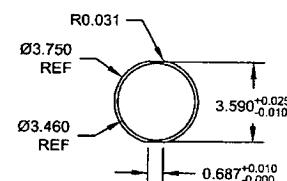


D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

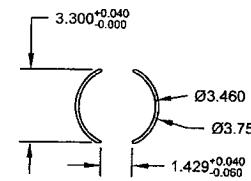
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SECTION A-A
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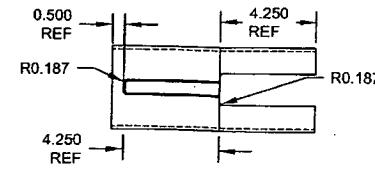


SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

B



VIEW Z-Z
SCALE 2X

A

05249

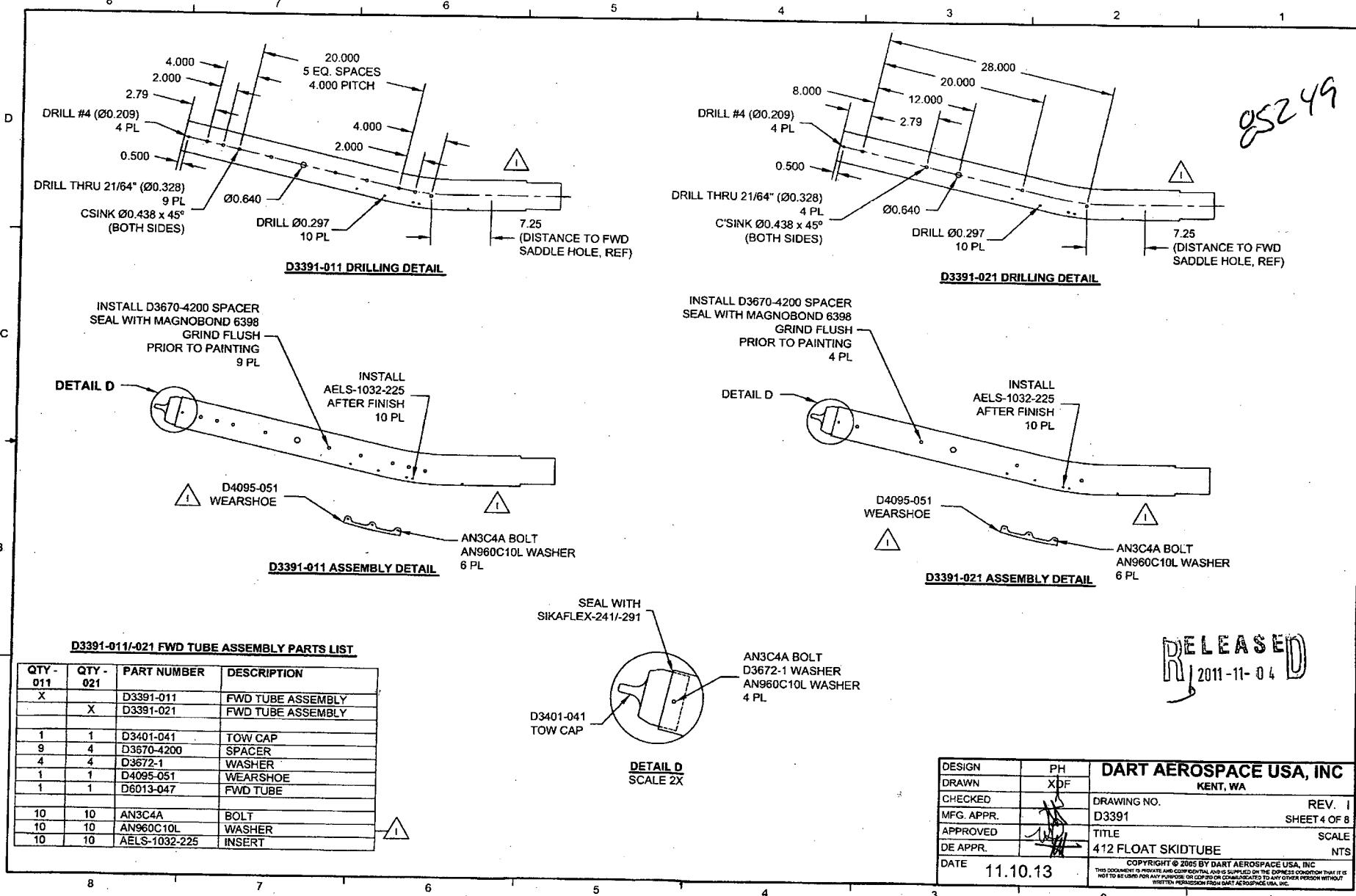
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2011-11-04

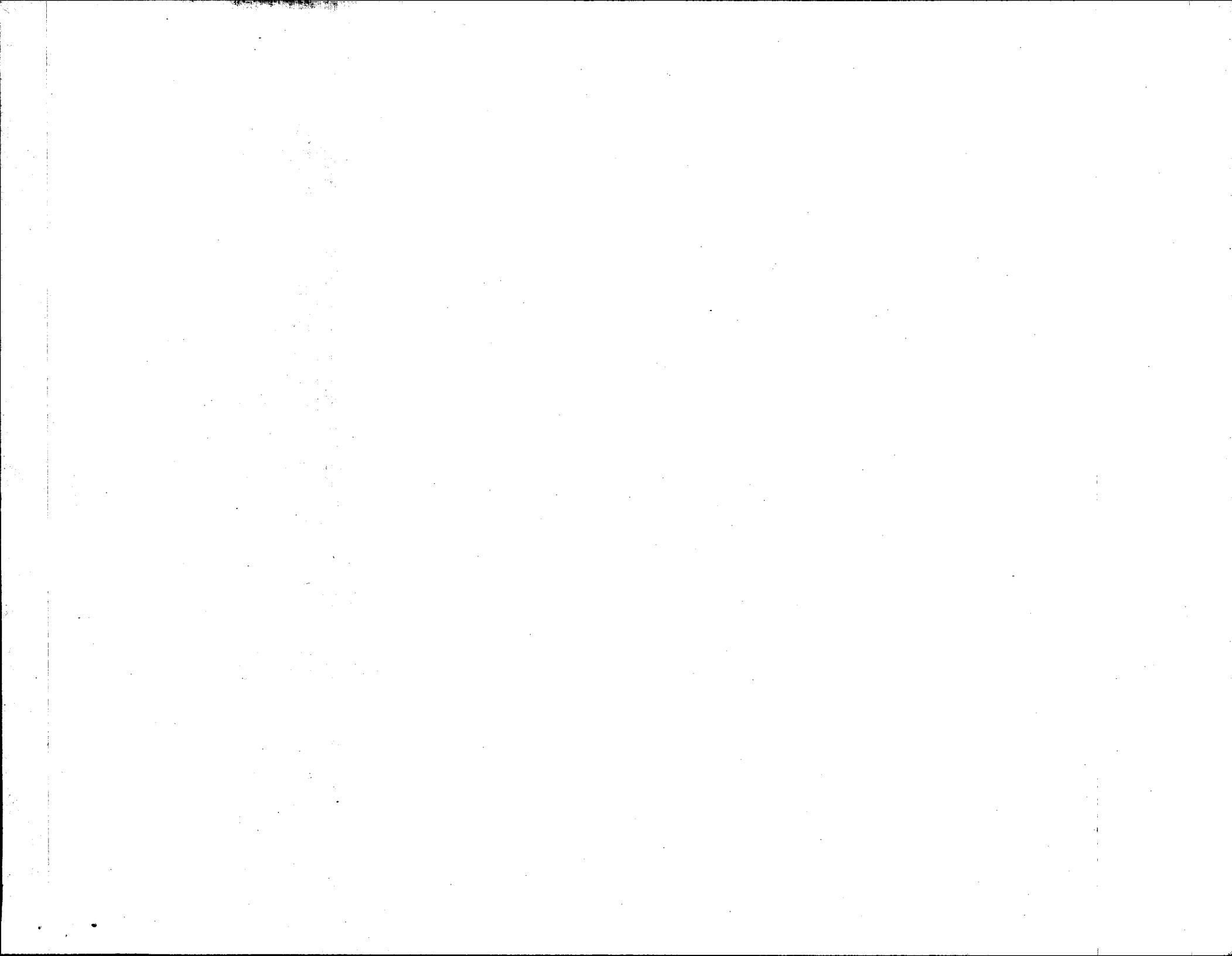
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APPROVED		D3391
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DATE	11.10.13	TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS

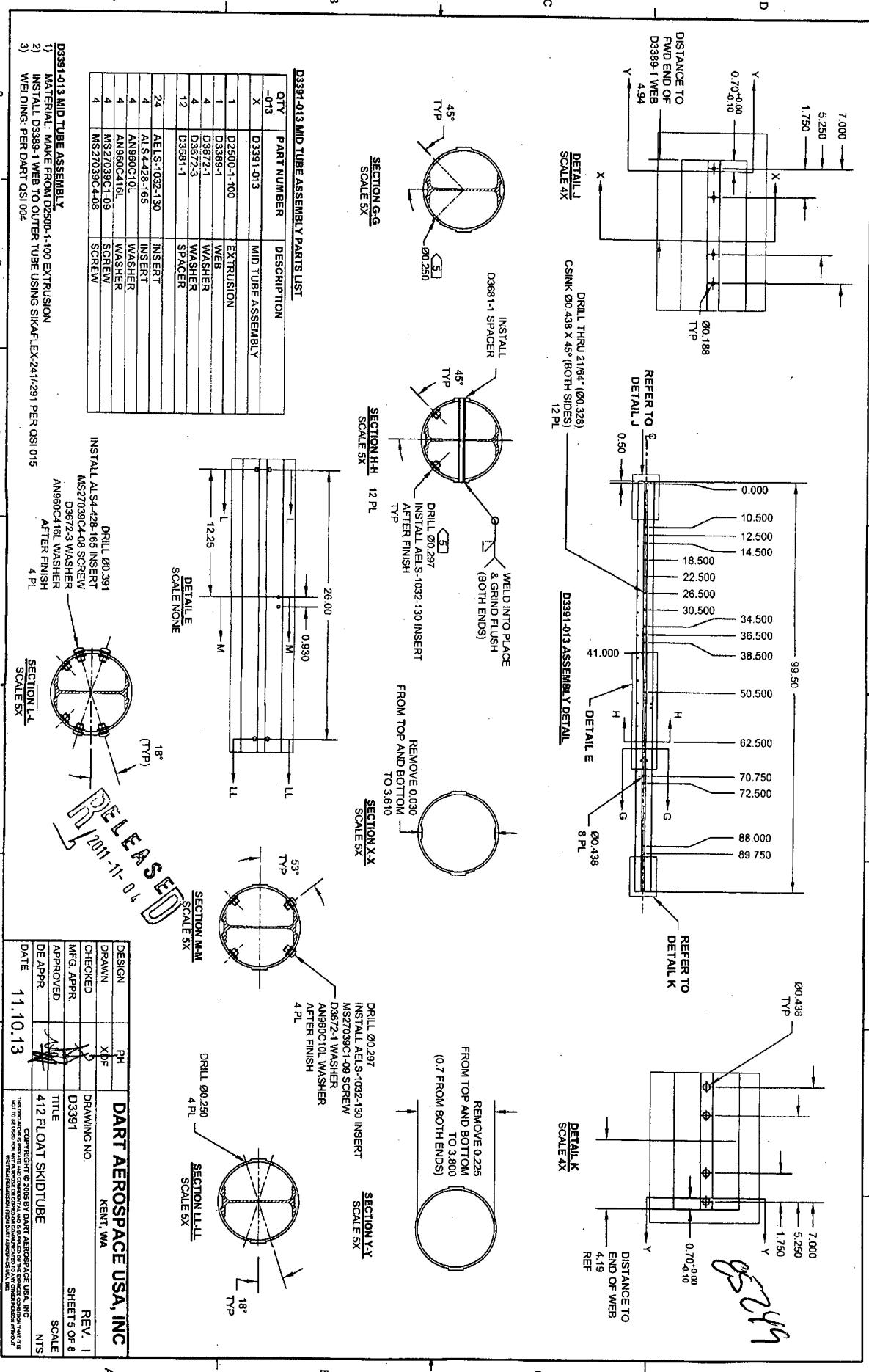
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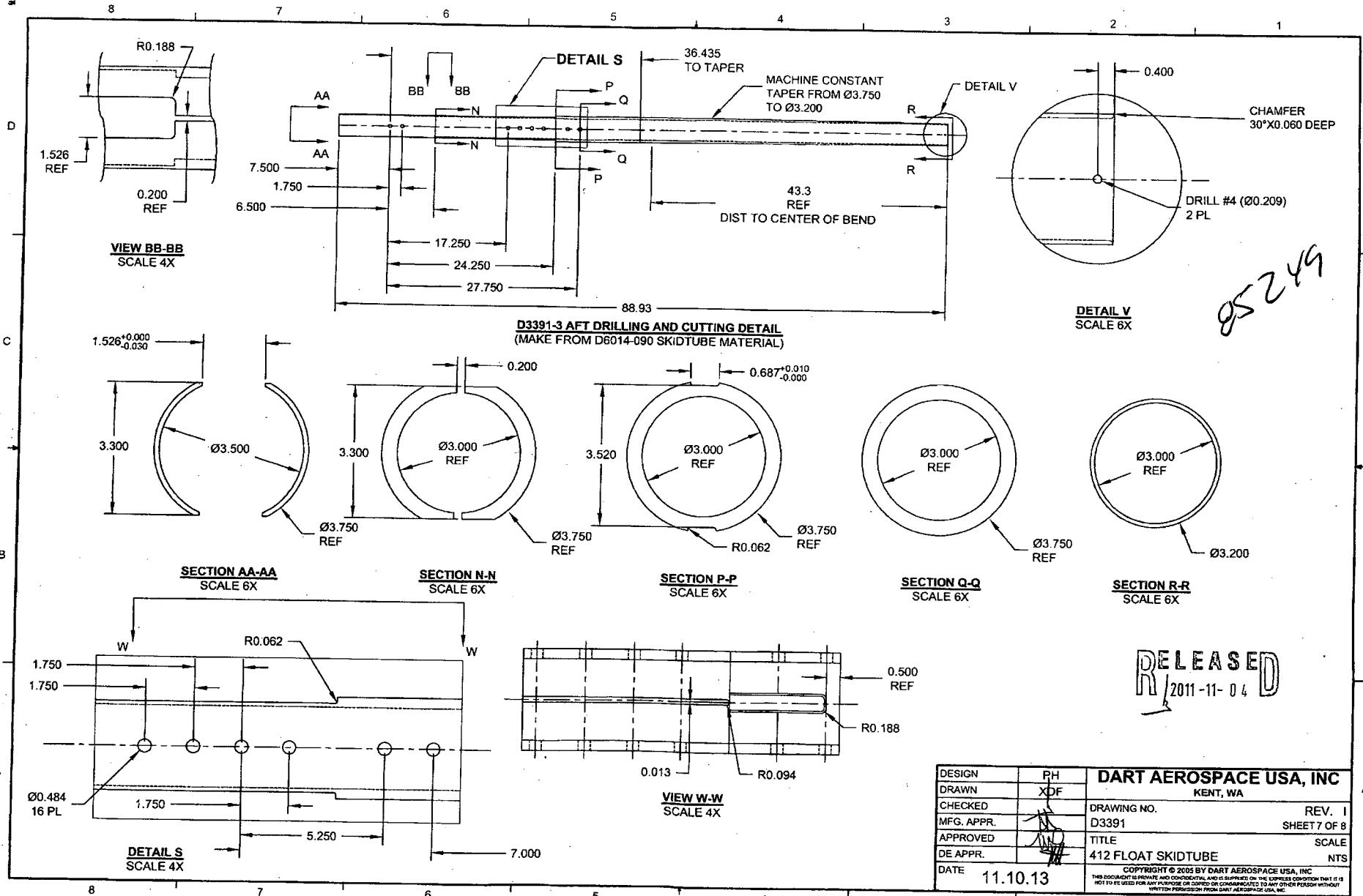
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